

Date: Friday, 12/12/2008 7:51:43 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 44030	
Estimate Number : 10566	
P.O. Number :	Part Number : D34435
This Issue : 12/12/2008 S.O. No. :	Drawing Number : D3443 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / 1 Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 41857	Material :
Written By : <i>[Signature]</i> 02-12-12	Due Date : 19/12/2008 Qty: 10 Um: Each
Checked & Approved By :	
Comment : A 05.11.14 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W120	304 ss round tube .750 x .120w
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Comment: Qty.: 0.5198 f(s)/Unit Total : 5.1975 f(s)

Inventory

AISI 304 SS seamless tubing .750 OD x 0.120 wall

(M304TR0750W120)

Batch: 109162

[Signature] 08/12/14

10 pcs

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

→ Man. Lathe Cut & Faced to length

1-Cut blank 5.97" long

2-Deburr

[Signature] 08/12/14

10 pcs

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1- Mill to length and drill holes as per dwg D3443

2-Deburr as per dwg D3443

[Signature] 08/12/14

10 pcs

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 08/12/14

10 pcs

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J-F. 08/12/14

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 44030

Part Number: D34435

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl

AS 08/12/15

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08.12.15

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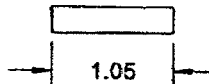
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

$\phi 0.210^{+0.005}_{-0.010}$



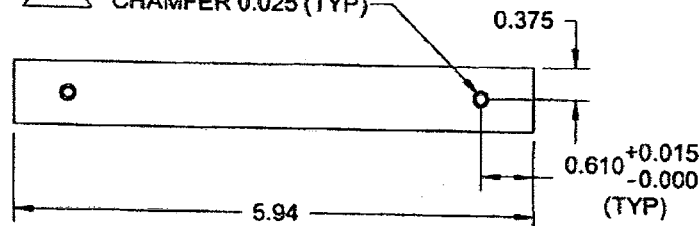
D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

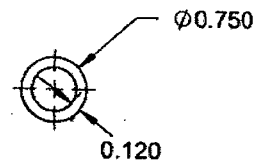


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)



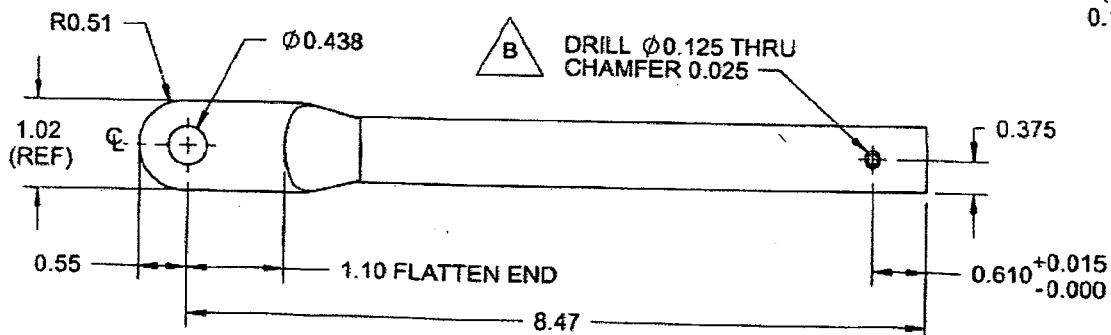
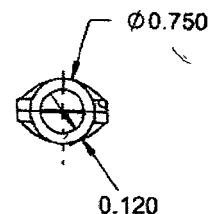
D3443-5 TUBING

RELEASED
05.12.09



W/O 44030

$0.260^{+0.000}_{-0.030}$



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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